

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151579-1	G	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151579-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151579-1	G	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151579-2	G	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151579-7	F	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	3.94 mm [.155]	O

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: POWER QUADLOK CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.20-5.80 mm [.205-.228 IN]		Ø3.40-3.70 mm [.134-.146 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18141-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968073-2	968132-2	1241602-2	1241615-2
968073-3			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm2	2.34+/-0.05 [.092+/- .002]	6.0

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5. ITEM 34 TO BE USED FOR TERMINAL PN 968073-2 AND 968132-2.
- 6. ITEM 261 TO BE USED FOR TERMINAL PN 1241602-2 AND 1241615-2.
- 7. CUT TO LENGTH AT ASSEMBLY.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- 9. TERMINAL LUBRICANT IS RECOMMENDED.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

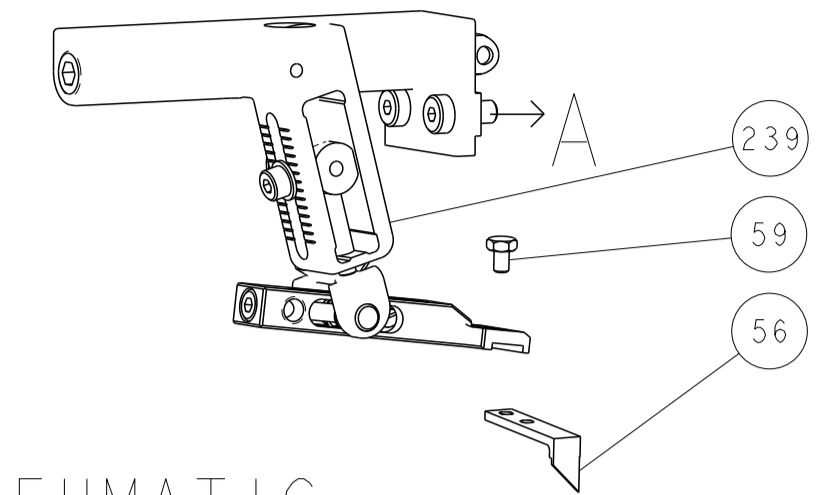
LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		E		ECR-21-110242	16AUG2021	FJ	RK
		F		ECR-21-115841	30SEP2021	LG	GB
		F1		ECR-22-148129	04AUG2022	FJ	YY
		G		ECR-24-202074	07MAR2024	FZ	TE

-	1	1	1	1	1803945-2	TONKER	300
-	1	1	1	1	22278-9	SPRING, COMPRESSION	299
-	2	2	2	2	4-18032-3	SCR, SET, FLT PNT, M3 X 6.0	298
-	1	1	1	1	1803944-1	SPACER, TONKER	297
6	-	1	1	1	2-1752356-0	SUPPORT, TERMINAL	261
-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
9	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
7	-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
5	-	1	1	1	6-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	3-2844962-2	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
7	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
8	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
8	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
8	1	2	2	1	1333208-8	ANVIL, COMBINATION .120	8
-	1	1	1	1	2-240641-4	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	7-238011-3	BLOCK, CRIMPER SPACER	4
7	1	2	2	1	4-1803018-2	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-3	SPACER, CRIMPER	2
7	1	2	2	1	2-456409-0	CRIMPER, WIRE .120 "F" PREMIUM	1
					-77-72-71-2-1	PART NO	ITEM NO

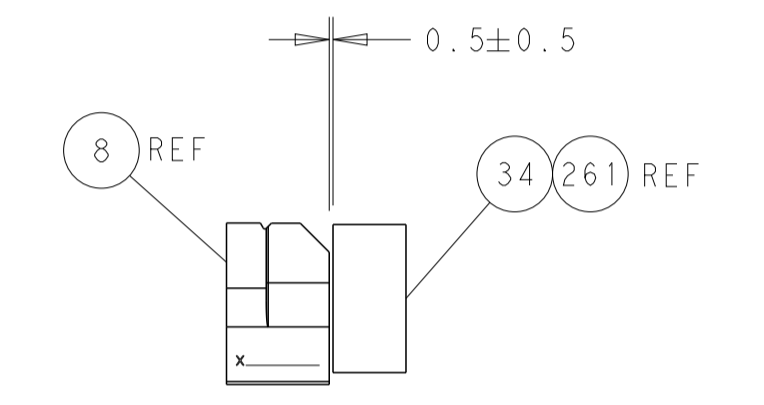
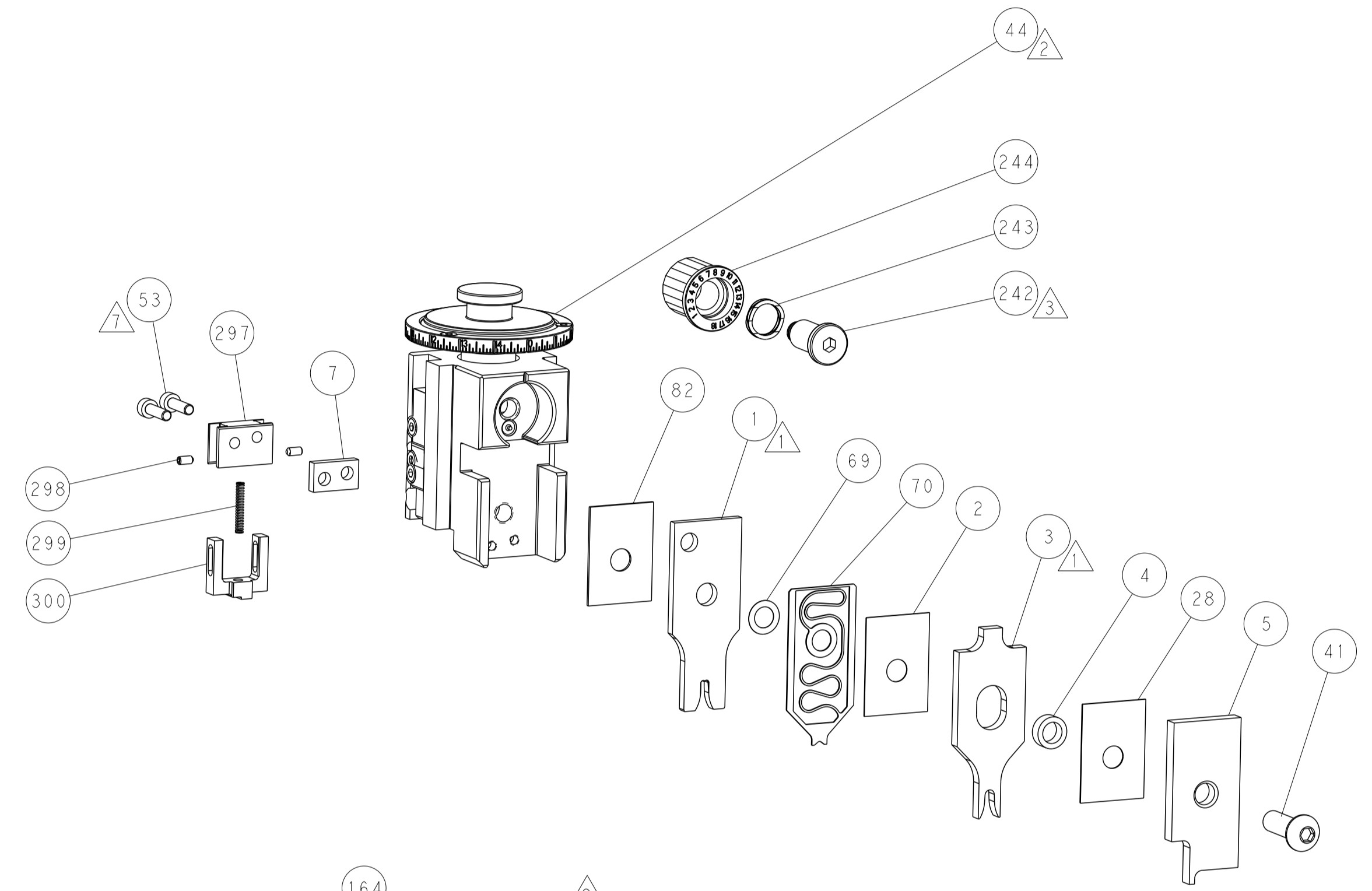
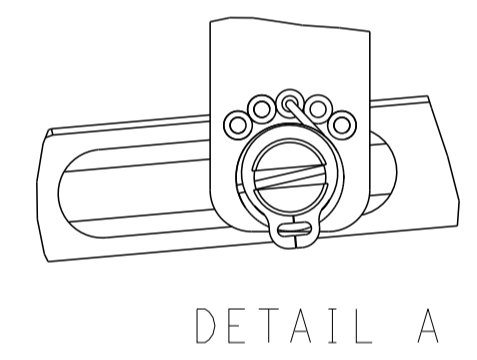
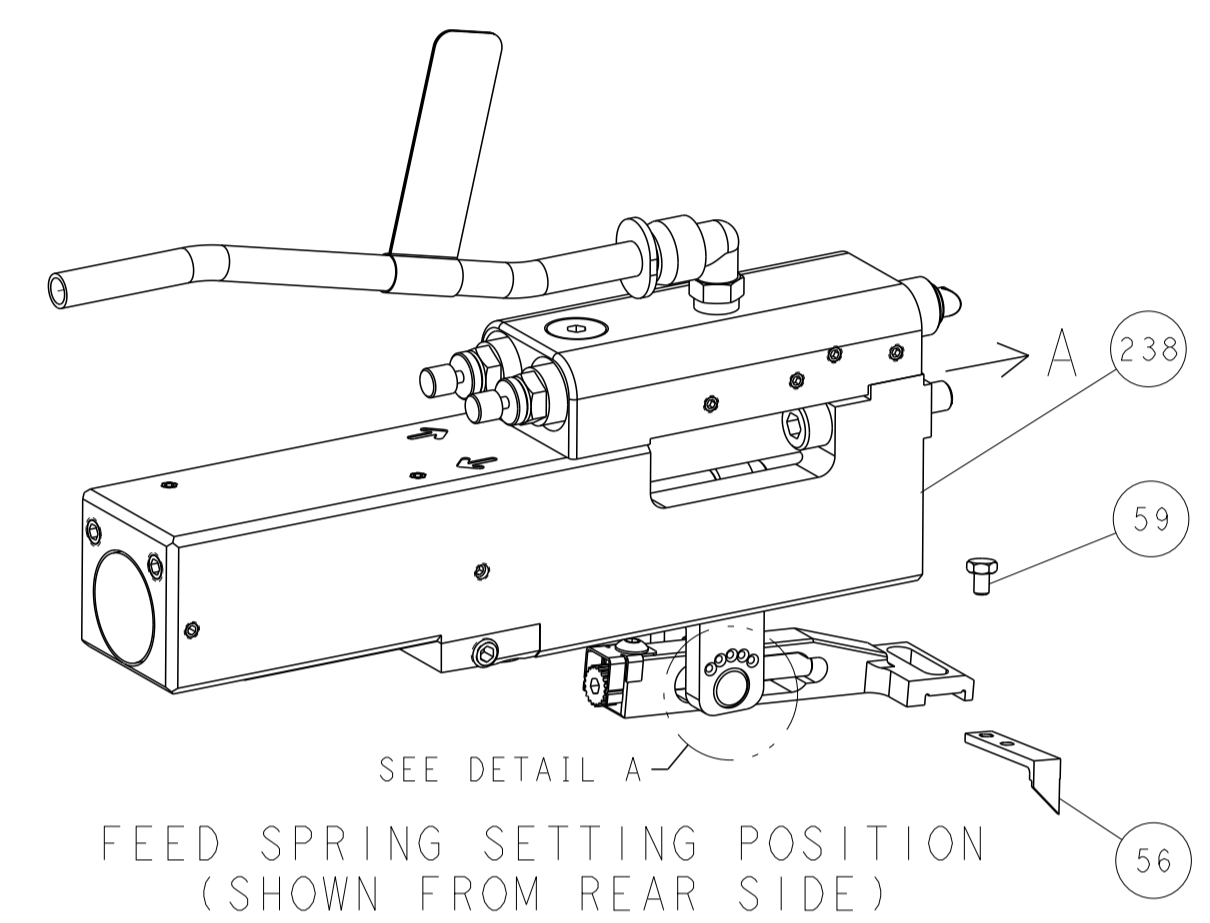
<small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED FOR THE MANUFACTURE OF THE PRODUCT SPECIFIED HEREIN. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE DISSEMINATED OUTSIDE THE COMPANY OR TO BE REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. ANY VIOLATION OF THESE TERMS SHALL BE SUBJECT TO LEGAL ACTION.</small>		DWN L. ZHANG 12JUN2012 CHK L. ZHANG 12JUN2012 APVD S. XI 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C=2151579 WEIGHT Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV G

LOC		DIST		REVISIONS			
A	66	P	LYN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1	-	-	-

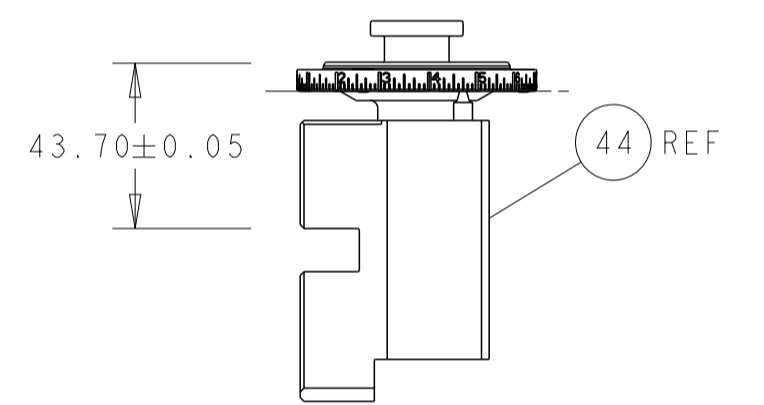
# FEED TYPE MECHANICAL



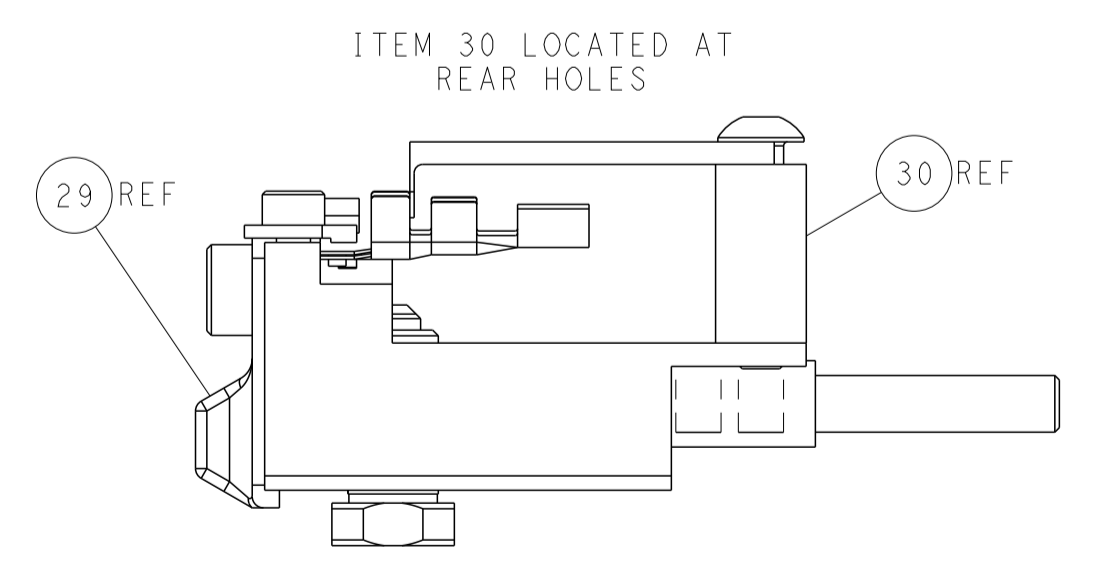
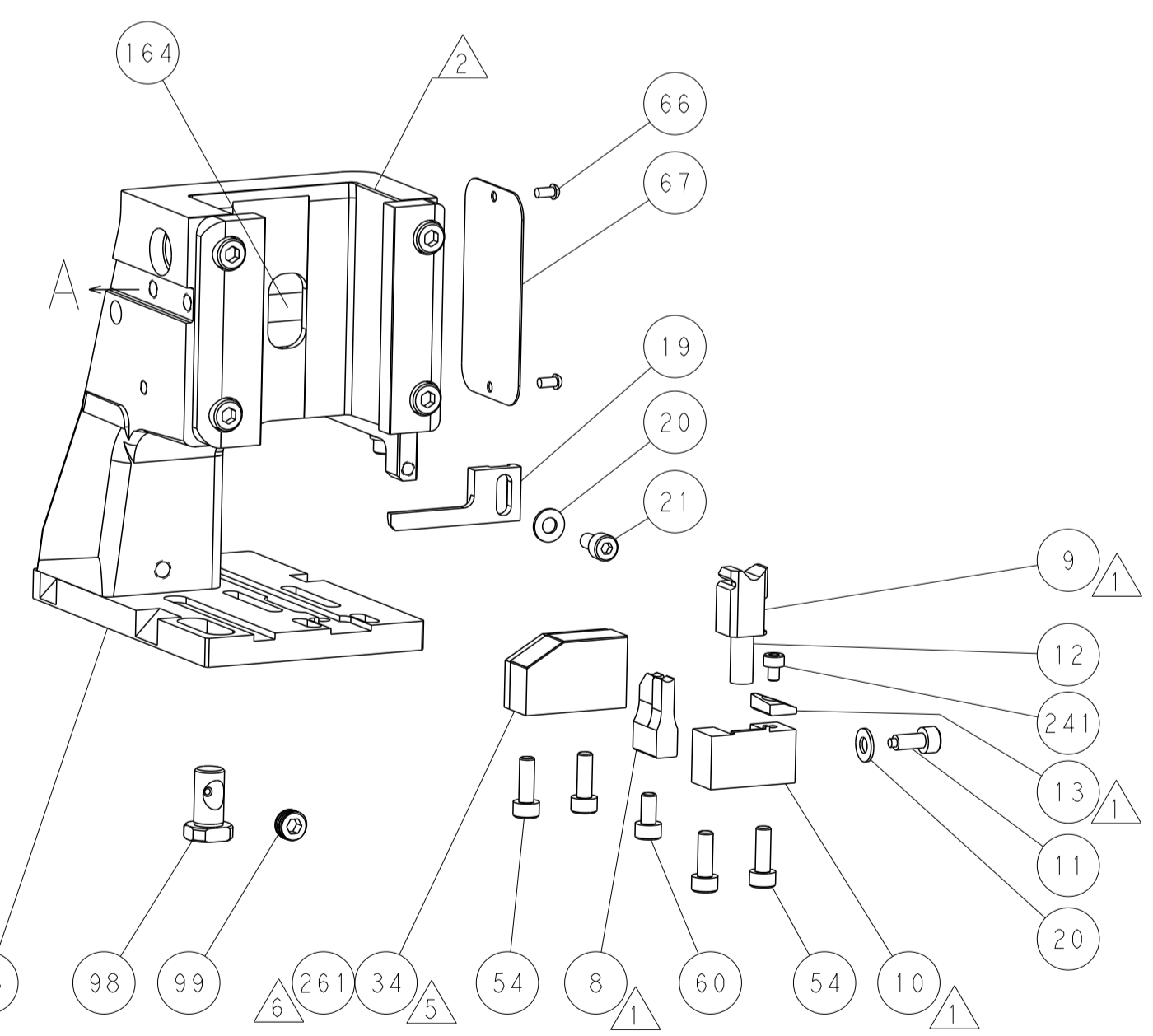
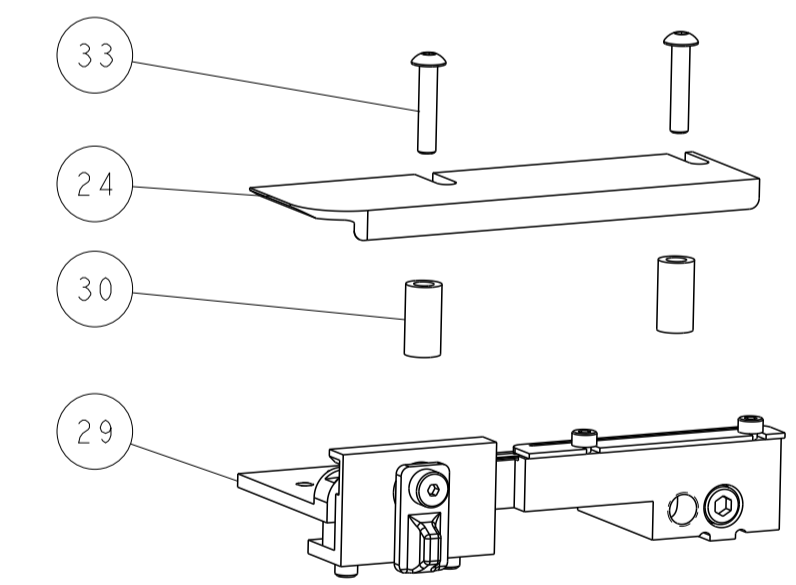
# PNEUMATIC



TERMINAL SUPPORT LOCATION

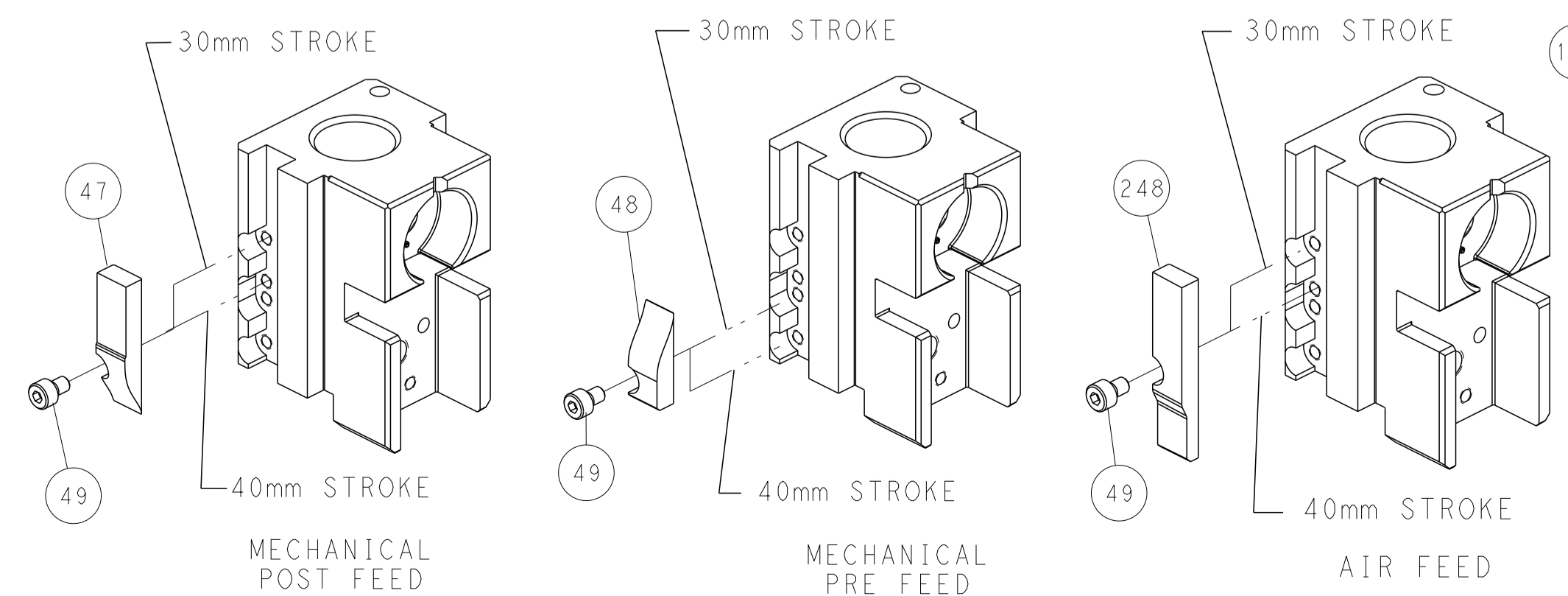


RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

# CAM POSITIONS



DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 12JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		APVD S. XI 12JUN2012		RESTRICTED TO	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
				APPLICATION SPEC		A1 00779 C=2151579	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV G	
				Customer Accessible Production Drawing			